Page 1

Thursday, June	23 2011	12:32:01 PA
		12.32.01 1 N
Item ID:	D3195-0	)43
Revision ID:		

Accept



Setup Start



Bracket Assembly

**Start Date:** 6/23/2011 Required Date: 7/11/2011

Start Qty: 4.00 Req'd Qty: 4.00

**Cust Item ID: Customer:** 

Reference:

Item Name:

Approvals:

Process Plan: MX

Date: (1-06-23) Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Accept Oty Code

Reject Oty

Reject Number

Insp. Stamp

**Draw Nbr** 

**Revision Nbr** 

QC:

D3195 Rev A

100

Bandsaw

BAND SAW

0.00

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

110



HAAS CNC VERTICAL MACHINING #1

Memo

0.00

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-

3[]2-Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

m/11/04/27

QC

Memo

Quality Control

0.00

W/0:71	139	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	profession and the second	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
11.428	170	OK to use 3M 1300L INSTEAD OF EPOXY	*	Sb '	1106/28	5	9 11.66.78 OSIUN	Sheeter		
						77 77 77		·		

Part No:	D3195-043	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NO						
		Description of NC	Description of NC Corrective Action Section B					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Approval QC Inspector
			1,					
		.•						
		•						
				:				
					:			
				*				
						1 - 1/4 May		
					,			
	1			1				1

Page 2

Thursday, June 23, 2011 12:32:01 PM

Item ID:

D3195-043

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 7/11/2011

Bracket Assembly

6/23/2011

Start Oty: 4.00 **Req'd Qty:** 4.00

**Cust Item ID:** 

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling: SPC (Y/N): Date:

Run

Start

Stop



Sequence ID/ Work Center ID

130

Quality Control

**Operation** Description

QC8-. Inspect parts - second check

QC: \_\_\_\_\_ Date: \_\_\_\_

Memo

Memo

Memo

Set Up/ **Run Hours** 

J. a 11/06/27

Tool # Plan Code

Date:

Accept **Qty** 

Reject **Qty** 

Reject Number Stamp

Insp.

140

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00 ~

0.00

0.00

0.00

bk 11-6-22

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

START TIME:

FINISH TIME:

**GOVEN TEMPERATURE:** 

5x & M-/ 11/06/28

W11812x

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	• .	DAD #.	Fault Oa						1		
Part NO		PAR #:									
4.	R	esolution:	Disposit	ion:		QA: N/C CI	osed:	Date: _			
NCR:	·	2 M. 93	WORK OR	DER NON-CO	ONFORMAN	ICE (NCR	)				
DATE	STEP	Description of NC		Corrective Ac			Verification	Approval	Approval		
		Section A	Initial Chief Eng		Description lef Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
·			g.s#								
		<b>*</b>		·				·			
		संख्या स्थित		<del></del>					,		
		·	A CONTRACTOR SERVICE		•						
`&		·			·			· .			
								-	-		
						1.					

Page 3

Thursday, June 23, 2011 12:32:01 PM

Item ID:

D3195-043

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Bracket Assembly

**Start Date:** 

6/23/2011

Start Oty: 4.00

Required Date: 7/11/2011

Req'd Qty: 4.00



Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start Stop

Sequence ID/

**Work Center ID** 

Quality Control

**Operation** Description

Small Fab

OC3- Inspect Part Finish

Memo

Date: \_\_\_\_\_

Set Up/ **Run Hours** 

SPC (Y/N):

0.00

0.00

0.00

0.00

0.00

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

BL 11-6-28

170

160

Small Fab Small Fab

Memo

13006

QC5- Inspect part completeness to step on W/O

SB 11/06/29



PTO 10 Food

180

Quality Control

Memo

0.00 8 Wo4/75

	oopaoc	Liu							
W/O:			N	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
: 									
								:	
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C C	losed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
		•							
									;
									i.
								i	
				. •					

#### Work Order ID 71139

Thursday, June 23, 2011 12:32:01 PM



Page 4

Item ID:

D3195-043

Accept

Setup Start

Stop

**Revision ID:** Item Name:

Bracket Assembly

**Start Date:** 

Required Date: 7/11/2011

6/23/2011

Start Qty: 4.00

Req'd Qty: 4.00

**Cust Item ID: Customer:** 

**Tool ID** 

Reference:

A	pprovals:	
$\boldsymbol{\alpha}$	DDI UVAIS.	

Date:

**Tooling:** 

Date:

Run

Start



Date: \_\_\_\_

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** 

Operation Description

Identify as per dwg & Stock Location: 5 + 246A

Set Up/ **Run Hours** 

0.00

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

190

Packaging Packaging

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

n 10/29/77 CMF 11-06-2

W/O:			WC	RK ORDER CHA	NGES					
DATE	STEP	PRO	OCEDURE CHAI			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,			Ÿ							
			2							
Part No		PAR #:	Fault Cate	jory:	NCR	: Yes I	No DQ	<b>A</b> :	_ Date: _	
	Re	esolution:	Disposition: QA: N/C Closed						Date: _	
NCR:			WORK ORDE	R NON-CONFOR	RMANCE	(NCR)	,			
DATE	STEP	Description of NC	Description of NC						Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
				-						
· ·						÷				
	_									
				•						
							,			

#### **Picklist Print**

Thursday, June 23, 2011 12:31:59 PM

Work Order ID: 71139

Parent Item:

D3195-043

Parent Item Name: Bracket Assembly



Start Date: 6/23/2011

Required Date: 7/11/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

c,		-	^-	400	
1	JIH	141	t i	ts:	

IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7		Manufactured	Nọ			100	Each	9.0000	1	4 As	11(00)	(B)	
				Location		Loc (	<u>Oty</u>	Loc Code					

V							
M6061T6B1.500X01.25	Purchased	No		170	f	22.4278	0.3
			69385		9		
			GA		9		



6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT004	22.4278	
110936	10.4278	
118071	12	

1.263158

<b>D</b> uit 710	Jopass	Liu								
W/O:			WO	RK ORDER CHANGE	S					
DATE	STEP	PROC	EDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									,	
				·						
								·		
Part No	:	PAR #: Fault Category: NCR: Yes No DQA: Date: _								
	Re	esolution:	_ Disposition		QA: N/C Closed: Date:					
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCR	)				
DATE	STEP	Description of NC		n B Sign &	Verific	ation	Approval	Approvai		
	0.2.	Section A	Initial Chief Eng			Secti	on C	Chief Eng	QC Inspector	
							, •			
,		·								
								·		
***										

DART AEROSPACE LTD	Work Order:	7//39
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.433			Vern	nl-7
1.265	+/-0.010	1.241		1.05.	. ,	1,
R0.37	+/-0.030	2.370			R-6	
Ø0.277	+0.005/-0.000	8.278			Ven	12-7
2.677	+/-0.005	2.677			10	11
0.242	+/-0.010	.244			, ,	. (
0.377	+/-0.010	. 378			10	(.
0.500	+/-0.010	499			11	٠,
R0.188	+/-0.010	R.188			R-la	
0.250	+/-0.010	.247			Vem	71-7
0.882	+/-0.010	.883			1.	1.
1.250	+/-0.010	1.248				
0.500	+/-0.010	.500	_		71	( )
Ø0.191	+0.005/-0.000	8.192			11	- ,
1.000	+/-0.010	1.001	/		A1	1.
,						
	·					
				,	1,00	

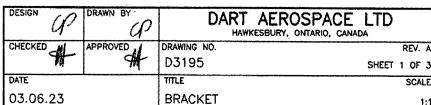
Measured by:	and	Audited by:	\$.A	Prototype Approval:	N/A
Date:	11/06/27	Date:	11/06/27	Date:	N/A

Rev	Date	Change	•	Revised by	Approved
Α	04.04.20	New Issue	(P/O D412-702-011/-013)	KJ/RF	21
В	05.04.26	R0.37 was R0.	037; 1.084 removed	KJ/JLM 🚓	411

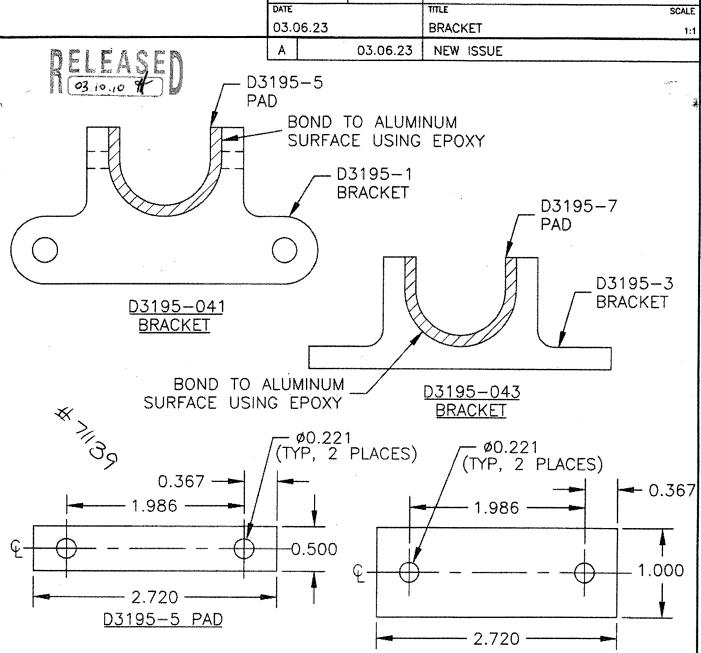
Dail Acioopace Eta	Dart A	Aeros	pace	Ltd
--------------------	--------	-------	------	-----

W/O:			V	VORK	ORDER C	HANGES		***			
DATE	STEP	PROCE	EDURE CH	IANGE	9'		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					,		,	
									1	-	
			:					•	*	*	
					·						
Part No:		PAR #:	Fault Ca	tegory:		NO	CR: Yes	No DQ	<b>\</b> :	_ Date: _	
	Re	esolution:	Disposit	ion:	331	Q,	QA: N/C Closed:			Date:	
NCR:					ON-CONF						
DATE STEP		Description of NC	Corrective Action Section B				10:0	Verific	ation	Approval	Approval
		Section A	<b>Initial</b> Chief Eng	,	Action Descr Chief Eng	ription	Sign 8 Date	Section	on °C	Chief Eng	QC Inspector
								-	,		
····	,				· · · · · · · · · · · · · · · · · · ·						
			,								
		·									
· 				•. •				_			
									,	, .=	:
No. of the second											
1	1		1	1			1	i		1	ı





D3195-7 PAD



#### D3195-5 & D3195-7 PAD

- MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK (POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DARY AEROSPACE LTD.

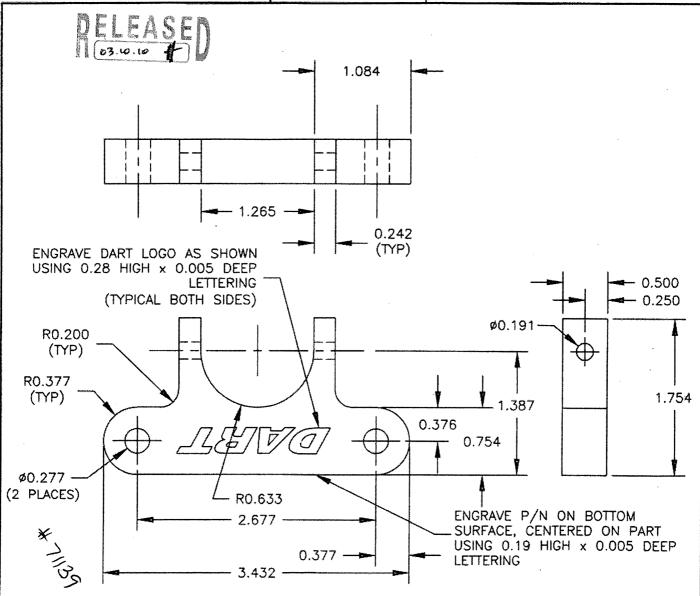
Dart	Aer	osp	ace	Ltd
------	-----	-----	-----	-----

	1	— - <del>-</del> -							
W/O:			WC	RK ORDER CHANGE	S				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-					· .			
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	·
	Resolution: Disposition:				QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC Corrective Action			n B	Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Description Sign 8 hief Eng Date		on C	Chief Eng	QC Inspector
		·							
l	1 1		1		1	ŀ		i	1





DESIGN (	DRAWN BY		AEROSPACE LTD SBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
TM	711	D3195	SHEET 2 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1



#### D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

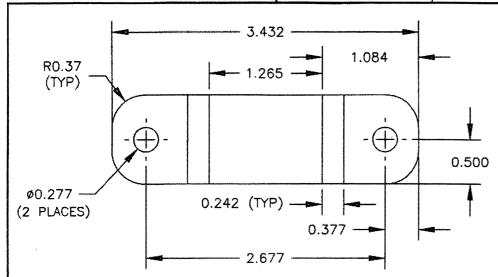
Copyright © 2003 by DART AEROSPACE LTD

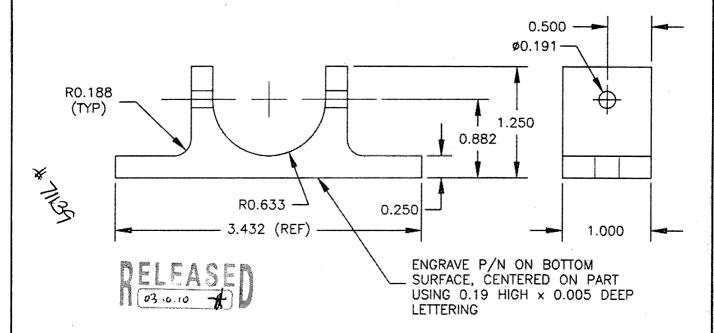
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

	. Johann	,							
W/O:			WO	RK ORDER CHANGI	ES				<u></u>
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·				
-									
Part No:PA		PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:				
Resolution:			Disposition	:	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NO	CR)			
DATE	STEP	Description of NC		Corrective Action Section B		Verifi	cation	Approvai	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&r ∣ <sub>Sect</sub>	tion C	Chief Eng	QC Inspector
_		·		·					
,									
		·							



DESIGN (P)	DRAWN BY		ROSPACE LTD Y, ONTARIO, CANADA
CHECKED	APPROVED N	DRAWING NO.	REV. A
#	AL.	D3195	SHEET 3 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1





#### D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010 3) FINISH: POWDER COAT GREY SANDTEX (4.3 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Insp.  Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:	pector
Part No:PAR #: Fault Category:NCR: Yes No DQA: Date:  Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Operation Section B Section C Se	
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC	
Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:  Resolution:Disposition:QA: N/C Closed:Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC	
Resolution:	
Resolution:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Initial Action Description Sign & Section C Sectio	<del></del>
DATE STEP Description of NC Section A Section B Section B Section C Section A Section C Section	
DATE STEP Description of NC Initial Action Description Sign & Verification Approval	
Section A Initial Action Description Sign & Section C Chief Eng   QC Inst	oval
	pector
	•